

Date: Tuesday, 11/29/2005 7:06:45 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET	
Job Number	: 25067				
Estimate Number	: 11110				
P.O. Number	: N/A		Part Number	: D33047	
This Issue	: 11/29/2005 S.O. No. : N/A		Drawing Number	: D3304 REV B	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: B	
Previous Run	: N/A		Material	: N/A	
Written By	: EST REV:B KJ.		Due Date	: 12/13/2005 Qty: 20 Um: Each	
Checked & Approved By	: SEE ABOVE			Z1	
Comment	: Created By Auto Work Order				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING D 33047 F
Comment: PURCHASING Issue P/O: 100000196 05/11/30 Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3304 Possible Supplier: GFI & Industrial Laser Material release note is required		

Tools:

2.0	D33045F	Bracket
 Comment: Qty.: 1.0000 U(s)/Unit Total : 20.0000 U(s) Bracket		

Tools:

3.0	PACKAGING 1	PACKAGING RESOURCE #1
 Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached		

Tools:

4.0	QC6	DIMENSIONAL CHECK
 Comment: DIMENSIONAL CHECK		

Tools:

 Signature: J. 06.04.03		
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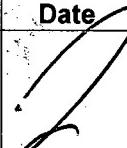
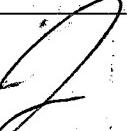
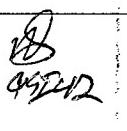
W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/03

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng			
06-01-03	5	holes not exactly made to dwg. 0.010" under due to laser cut.		Finish holes AS per Dwg.	 06-01-31	 06-01-31	 06-12-03

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 25067

Part Number: D33047

Job Number:



Seq.#: Machine Or Operation:

Description:

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

DL 06/01/06 21

Tools:

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

- 1-Deburr
- 2-Form as per Dwg D3304
- 3-Tumble ~~Paint~~

SB 06/01/17 21

PL 06/01/23 21

PID

Tools:

7.0 QC5

INSPECT WORK TO CURRENT STEP



06/01/17 21

Comment: INSPECT WORK TO CURRENT STEP

Tools:

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 414

06/01/24 21

Tools:

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21 SUC 06/01/26

(21)

06/01/25 21

Tools:

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-01-17	6	No tumble req'd. parts to be welded. remove tumble. <i>permanent change</i>	R	06-01-17	1	06-01-17	06-01-17

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/25
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

品成實業股份有限公司
YIEN MAU CORP.

DIVISION NO.:
COMMUNITY:

FORMASS

PRIME COLD ROLLED STAINLESS STEEL SHEET AISI 304/NO4 (SIC)
FINISH, WITH 100 MICRUM ON MAIN SIDE, WITH BACK-PASS,
SLITTED EDGE/AISI 304/2B FINISH, WITH PAPER INTERLEAVED,
SLITTED EDGE.

AISI 304

INTEGRIS METALS LTD

INSPECTION CERTIFICATE

MATERIAL TEST/INSPECTION CERTIFICATES

地址:高市新竹縣頭前鄉安仁里45號
345, SHUN AN RD. LU CHU HSIEH
KAOHHSIUNG TAIWAN R.O.C.
TEL: (07) 9222445 FAX: (07) 9223066
CERTIFICATE NO: 3011112
DATE OF ISSUE: 1/24/2004

SPECIFICATION:
CUSTOMER:

(ITEM NO.) SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test GL-50 mm/m					Chemical Composition (%)							
		KGS	LBS			Y.S. (kg/mm ²)	T.S. (kg/mm ²)	E.I. (%)	H.R.B.	H.V.	C x100	Si x100	Mn x100	P x1000	S x100	N x100	Cr x100	N x100
AISI 304/2B																		
(7025-4220)																		
24GA/48"X120"	1	1,465	3,230	YU231320	3AS44463B-21	268	605	56	81	156	4.6	51	119	24	2	804	1821	2.7
24GA/48"X120"	1	1,464	3,228	YU231320	3AS44463B-22	268	605	56	81	156	4.6	51	119	24	2	804	1821	2.7
(7025-5860)																		
22GA/48"X96"	1	1,464	3,228	YU230510	38S376098-51	280	673	53	82	162	5.4	59	126	26	3	815	1819	2.4
(7025-5950)																		
22GA/48"X120"	1	1,375	3,031	YU230510	38S376098-52	280	673	53	82	162	5.4	50	128	26	3	815	1819	2.4
(7025-5850)																		
20GA/48"X96"	1	1,445	3,186	YU134975	3AS43434A-1	312	666	51	82	161	4.1	49	112	24	2	809	1821	2.8
(7025-2640)																		
18GA/48"X96"	1	1,497	3,300	YU231066	3AS42732-4	301	684	49	84	168	3.7	40	118	27	5	810	1824	3.7
(7025-2619)																		
18GA/48"X120"	1	1,453	3,203	YU231066	3AS42732-5	301	684	49	84	168	3.7	40	118	27	5	810	1824	3.7
18GA/48"X120"	1	1,455	3,208	YU231066	3AS42732-6	301	684	49	84	168	3.7	40	116	27	5	810	1824	3.7
G426-5160																		
16GA/48"X120"	1	1,423	3,187	YU231143	3AS42886A-6	302	659	53	82	159	4.5	52	123	28	4	810	1822	2.7
16GA/48"X120"	1	1,424	3,199	YU231143	3AS42886A-7	302	659	53	82	159	4.5	52	123	28	4	810	1822	2.7
16GA/48"X120"	1	1,420	3,131	YU231143	3AS42886B-1	302	659	53	82	159	4.5	52	123	28	4	810	1822	2.7
(7026-7049)																		
14GA/48"X96"	1	1,441	3,177	YU231075	3AS42917A-1	302	650	52	83	162	4.2	48	119	28	6	808	1813	3.4
14GA/48"X96"	1	1,441	3,177	YU231075	3AS42917A-2	302	650	52	83	162	4.2	48	119	28	6	808	1813	3.4
(7026-8059)																		
14GA/48"X120"	1	1,420	3,191	YU231075	3AS42917A-3	302	650	52	83	162	4.2	48	118	28	6	808	1813	3.4
14GA/48"X120"	1	1,420	3,131	YU231075	3AS42917A-4	302	650	52	83	162	4.2	48	119	28	6	808	1813	3.4
(7026-8240)																		
14GA/50"X96"	1	1,446	3,188	YU133202	3AS45623A-211	301	641	53	81	157	5.1	51	114	30	9	806	1822	3
(7026-8277)																		
14GA/50"X120"	1	1,405	3,097	YU135202	3AS45623A-213	301	641	53	81	157	5.1	51	114	30	9	806	1822	3
14GA/50"X120"	1	1,540	3,395	YU136202	3AS45623A-214	301	641	53	81	157	5.1	51	114	30	9	806	1822	3
	18	25,998	57,327															

Remark: NO MERCURY CONTAMINATION

Stamp assigned for all Heat No.

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.PRODUCT IN ACCORDANCE WITH ASTM A240, A480,
A262R, ASME SA240, QQS766D.

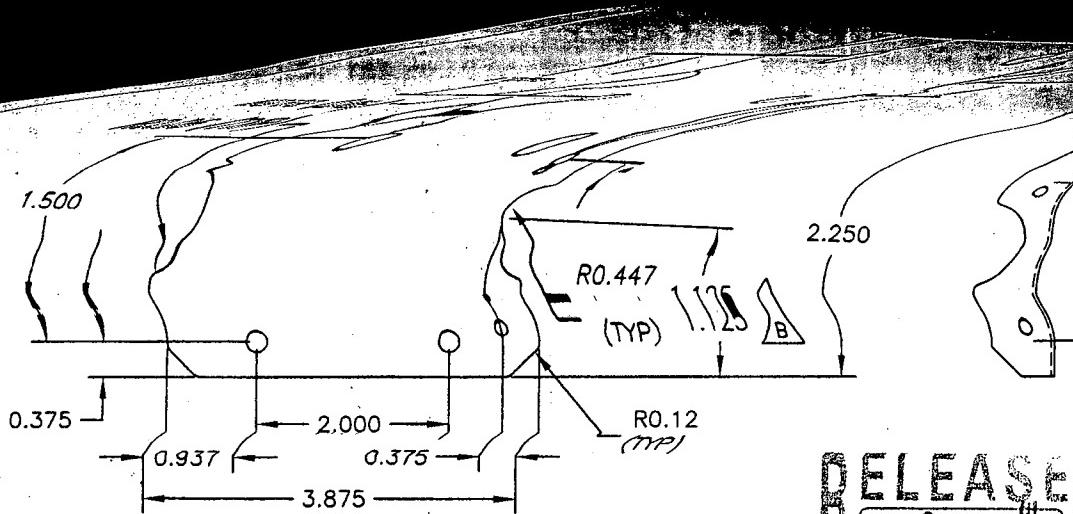
YIEN MAU CORP.

Jim Chen
Manager of Quality Assurance Department

20g^a 304 0455

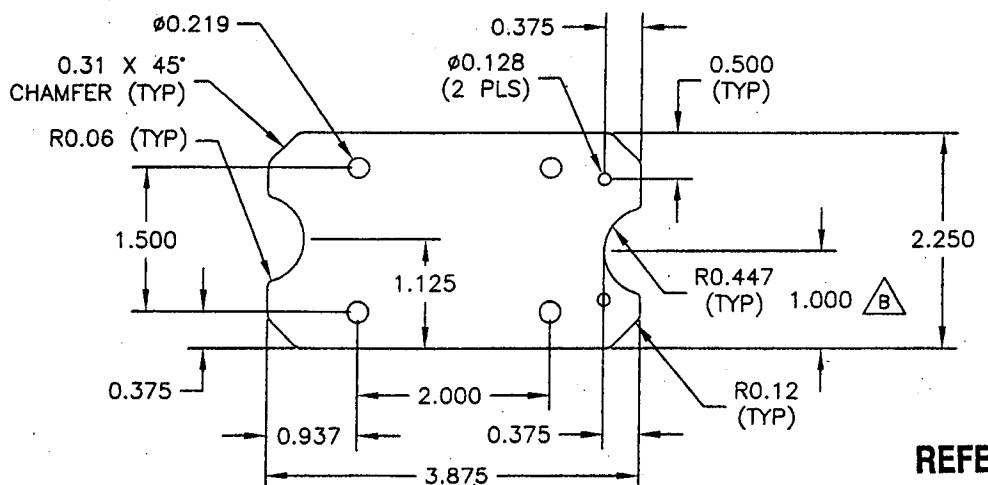
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206-01-03
PO # 267 196



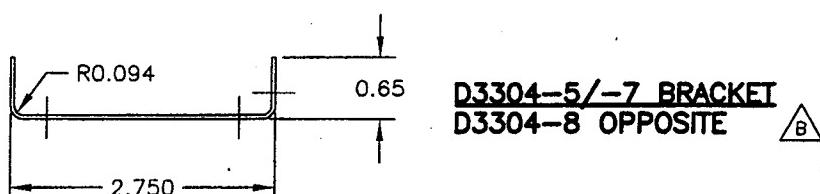
RELEASED
05.09.11

D3304-5 FLAT PATTERN



REFERENCE ONLY

D3304-7/-8 FLAT PATTERN



NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015